

Work Order ID 66847

Page 1

Monday, February 28, 2011 1:30:44 PM

Item ID: D3417-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Washer

Start Date: 2/28/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan: 

Date: 11-02-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3417

Rev E

100

0.00







DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA594 Rev:  & Dwg D3417 Rev:  □2-Deburr 11/3/230 

110

0.00





QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

 11/3/230 

120

0.00




QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

 11/03/0230 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Setup Start



Revision ID:

Stop



Item Name: Washer

Start Date: 2/28/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 053

0.00



Packaging

Memo

0.00

Packaging

4/3/3 (30)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/04 MF

MF

11-03-03

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Picklist Print

Monday, February 28, 2011 1:30:52 PM

Page 1

Work Order ID: 66847

Parent Item: D3417-3

Parent Item Name: Washer



Start Date: 2/28/2011

Required Date: 3/4/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A 05.10.19 New issue KJ/EC
IPP Rev:B 05.10.19 added haas op. EC
IPP Rev:C As per Rev D 08-07-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.2500		Purchased	No			100	f	26.1010	0.0296	0.934737			
DELRIN ROUND BAR 1.25"													

Location	Loc Qty	Loc Code
MAT	26.101	
114586	19.3	
114733	6.801	

55 11/3/12
1.4 Rf

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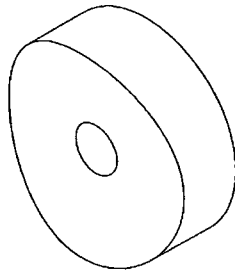
NOTE: Date & initial all entries

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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT²

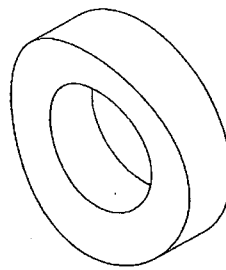
WITHOUT NOTICE
WORK ORDER

NO. 66-847

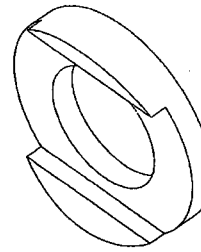
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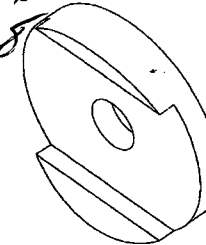
D3417-1 WASHER



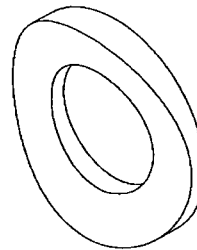
D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER



D3417-9 WASHER

RELEASED
2010-09-15

NOTES:

1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD
REF DART SPEC M-DELRIN-R
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELRIN-B
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
REF DART SPEC M-DELRIN-S

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: D3417-1, 0.020 lbs
D3417-3, 0.010 lbs
D3417-5, 0.010 lbs
D3417-7, 0.010 lbs
D3417-9, 0.004 lbs

F	ADD D3417-9 (ZN B5-3)	SC	10.07.26
E	ADD D3417-7 (ZN A2-2)	RF	09.06.30
D	ADD -5 WASHER (ZN B2-1, B2-2), REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS. REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
DATE	10.07.26	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR CONSTRUCTION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

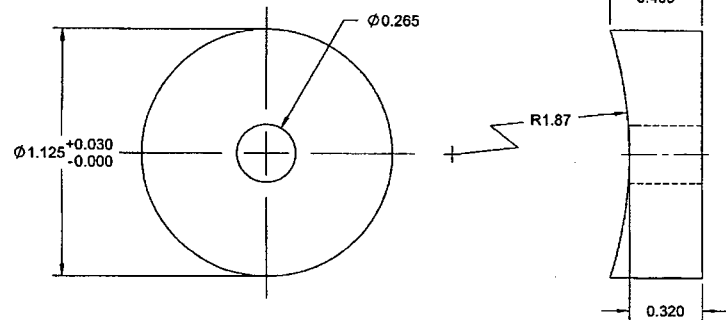
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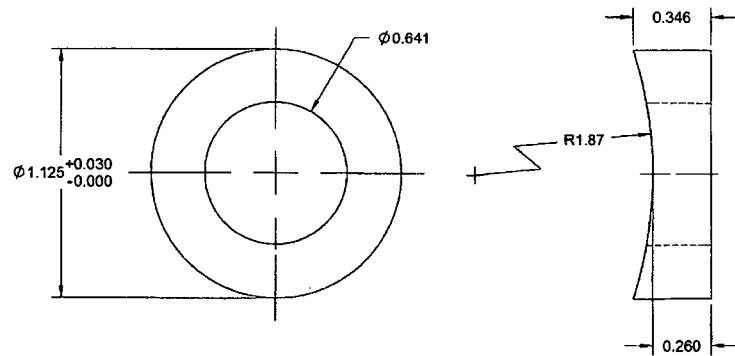
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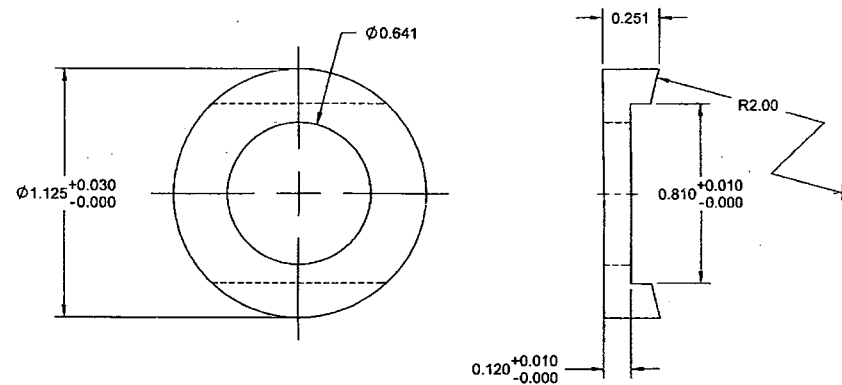
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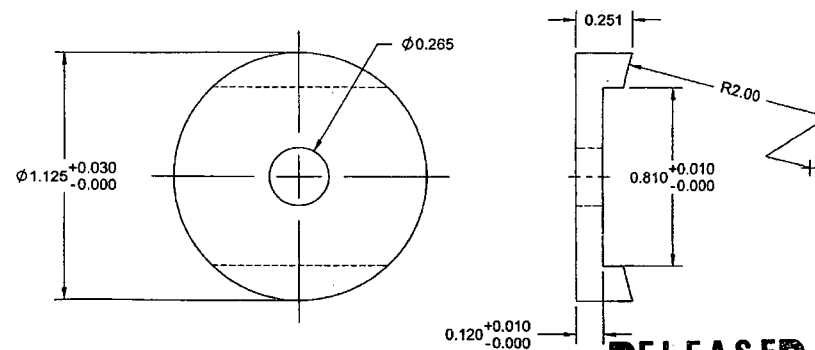
D3417-1 WASHER



D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER

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2010-09-15

elo 66847

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CHECKED		DRAWING NO. D3417	REV. F
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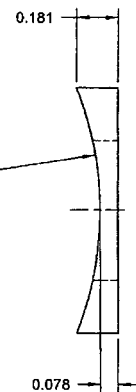
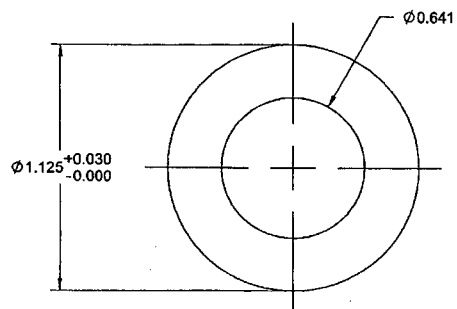
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D3417-9 WASHER



W/O 66847

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2010-09-15
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